

Date: Wednesday, 9/19/2007 10:13:04 AM
User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUFF	PROTOTYPE
Job Number : 34706	Part Number : D36591	
Estimate Number : 13022	Drawing Number : D3659 UNDER REV	FOR ENGINEERING USE ONLY
P.O. Number :	Project Number : N/A	
This Issue : 9/19/2007 S.O. No. :	Drawing Revision : U/R	
Prsht Rev. : NC	Material :	
First Issue : / / Type : MACHINED PARTS	Due Date : 9/24/2007	Qty: 4 Um: Each
Previous Run :		
Written By : <u>EC</u>		
Checked & Approved By :		
Comment : est rev A new issue 07.09.19 EC verified by:JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6009129P

Crosstube Material



Comment: Qty.: 0.3460 Each(s)/Unit Total : 1.3839 Each(s)
D6009-129 X-TUBE MATERIAL
batch: B26548

**CERTIFICATE OF CONFORMITY
REQUIRED**

EC

07.09.18

(4)

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per folio ^{N/A} ~~FA-707~~ & DWG D3659,
FOLIO REV: N/A
DWG REV: A

EC 07.09.18

(4)

2-Deburr as required

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EC 07.09.19

(4)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/09/19

(4)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

EC 07.09.19

(4)

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Drawing Name: CUFF

Job Number: 34706

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Job Number:



Seq. #:

Machine Or Operation:

Description :

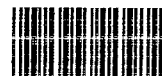
6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

U 07.09.24

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock *3*

Location: _____

FOR ENGINEERING USE ONLY

N/A

U 07.09.24

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U 07.09.25

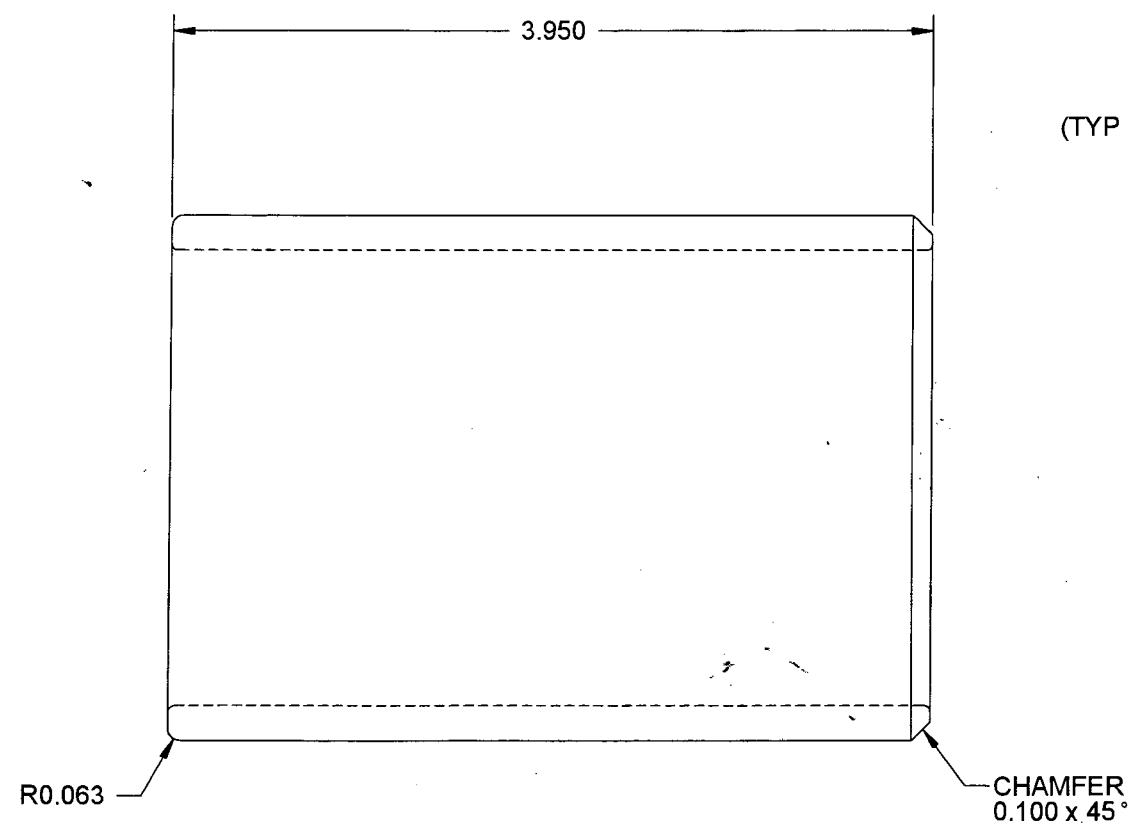
Job Completion



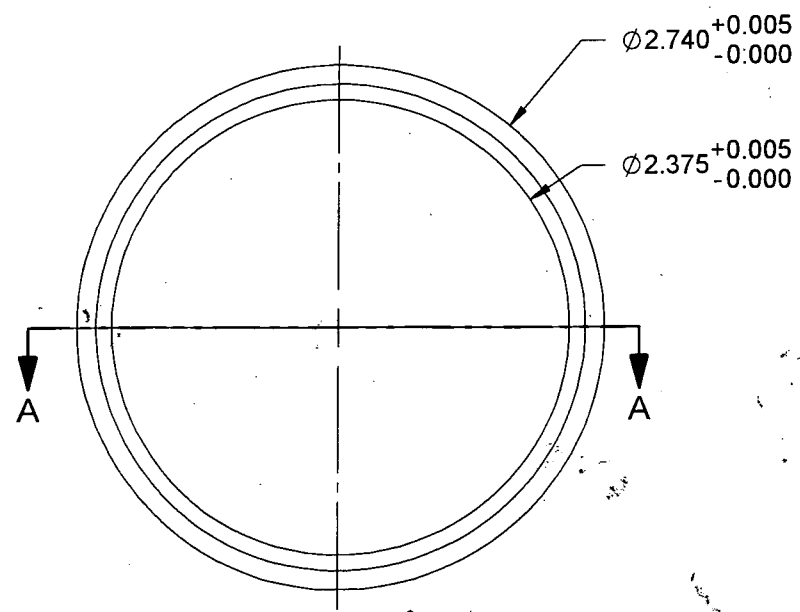
U 07.09.28

REF D3606

SECTION A-A



R0.032
(TYP INSIDE EDGES)



D3659-1 CUFF

- NOTES:
- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (VV-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6005, D6006, D6009, OR D6011)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) WEIGHT: 0.58 lbs

A	New Issue	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3659	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CUFF	1:1
DATE	07.07.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

